Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 24825B		
Estimate Number	: 10207		
P.O. Number	: N/A	Part Number	: D2989043
This Issue	: 11/19/2005 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 24824B	Material	: N/A
Written By	: See comment below	Due Date	: 12/15/2005 Qty: 1 Um: Each
Checked & Approved By	: See comment below		
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :

1.0   D31821   Hinge

Comment: Qty.:   2.0000 Each(s)/Unit   Total :   2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D3182-1	Hinge	B23085

N/\ 06/01/10

2.0   D34423   Shim

Comment: Qty.:   2.0000 Each(s)/Unit   Total :   2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D3442-3	Shim	B23545

N/\ 06/01/10

3.0   M304EX07516F   Expanded Metal Flat Stai

Comment: Qty.:   8.0000 sf(s)/Unit   Total :   8.0000 sf(s)
Pick:

Qty	Part number	Description	Batch
15sf	M304EX0.75-16F	Expanded Metal	M 18480

N/\ 06/01/10

4.0   M304TS0750W065   304 SQ Tube.75x.75x.065W

Comment: Qty.:   17.6400 f(s)/Unit   Total :   17.6400 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M 19447

N/\ 06/01/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ⟨signature⟩ Date: 06/01/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

| **Customer:** | CU-DAR001 Dart Helicopters Services | **Drawing Name:** BASKET LID ASSEMBLY |
| **Job Number:** | 24825B | **Part Number:** D2989043 |

Job Number:

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Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

06/01/12

| 6.0 | QC9/6 | DDIMENSIONAL & WELDING INSPECTION |

Comment: DDIMENSIONAL & WELDING INSPECTION   *PD   06-01-12*

| 7.0 | POWDER COATING | POWDER COATING |

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989   *06.01.12*

| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

Comment: Inspect Powder Coat   *06.01.12*

| 9.0 | DC | DOCUMENT CONTROL |

Comment: DOCUMENT CONTROL
Inspection Level 21   *06/01/16*   *06/01/16*

Job Completion

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD